

Work Order ID 82355

March-29-12 2:32:13 PM

82355

Page 1

Item ID: D4073-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Hinge
 Start Date: 29/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/29 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4073	B

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	cut blank 4.563" long								

105		0.00							
105									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg an Folio FA939								
	Dwg Rev: <u>B</u>								
	Folio Rev: <u>AA</u>								

Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	PO/642	12/05/05		12	0		
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/05/0		12	0		
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(12)	26	12-5-8	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating M121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 <i>Start Time: 1:10</i> 0.00 <i>Temp: 3200F</i> <i>Finish Time: 1:40</i>				<i>12x</i>	<i>Ø</i>		<i>M-L</i> <i>12/05/08</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>	<i>Ø</i>	<i>BR 1258.</i>	
180 *180* Packaging Packaging	Identify as per dwg & Stock Location Memo	<i>SF/20</i> 0.00 0.00				<i>12x</i>		<i>SD</i> <i>12-5-10.</i>	

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/5/10 DJ
MF
12-05-10

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Picklist Print

March-29-12 2:32:17 PM

Page 1

Work Order ID: 82355

82355

Parent Item: D4073-1

D4073-1

Parent Item Name: Door Hinge

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	28.9433	0.38	4.8			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

Location	Loc Qty	Loc Code
MAT009	16.94326358	
114899	4.15263158	
116623	2.15	
119136	10.640632	
MAT010	12	
→121040	12	
121660		

3.6
1.2

F.K 12/05/05

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DART AEROSPACE LTD		Work Order:	8235T
Description: Door Hinge		Part Number:	D4073-1
Inspection Dwg: D4073 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	0,125	✓		Rad gauge	
Ø0.203	+0.005/-0.001	0,204	✓		VERN	PHD-01
2.00	+/-0.030	1,999	✓		"	"
0.81	+/-0.030	0,805	✓		"	"
0.350	+/-0.010	0,350	✓		"	"
1.100	+/-0.010	1,102	✓		"	"
Ø0.500 x 0.125	+/-0.010	0,501 x 0,124	✓		"	"
0.340	+/-0.010	0,340	✓		"	"
1.320	+/-0.010	1,320	✓		"	"
4.44	+/-0.030	4,440	✓		"	"
4.13	+/-0.030	4,126	✓		"	"
R0.31	+/-0.030	0,310	✓		Rad gauge	
0.313	+/-0.010	0,315	✓		VERN	PHD-01
0.63	+/-0.030	0,620	✓		"	"
1.00	+/-0.030	0,999	✓		"	"
0.38	+/-0.030	0,375	✓		"	"
0.190	+/-0.010	0,188	✓		"	"
1.80	+/-0.030	1,800	✓		"	"
0.25	+/-0.030	0,247	✓		"	"
R0.13	+/-0.030	0,125	✓		Rad gauge	

Measured by:	PD/azf
Date:	12/05/05

Audited by:	B.A
Date:	12/05/05

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	

Dart Aerospace Ltd

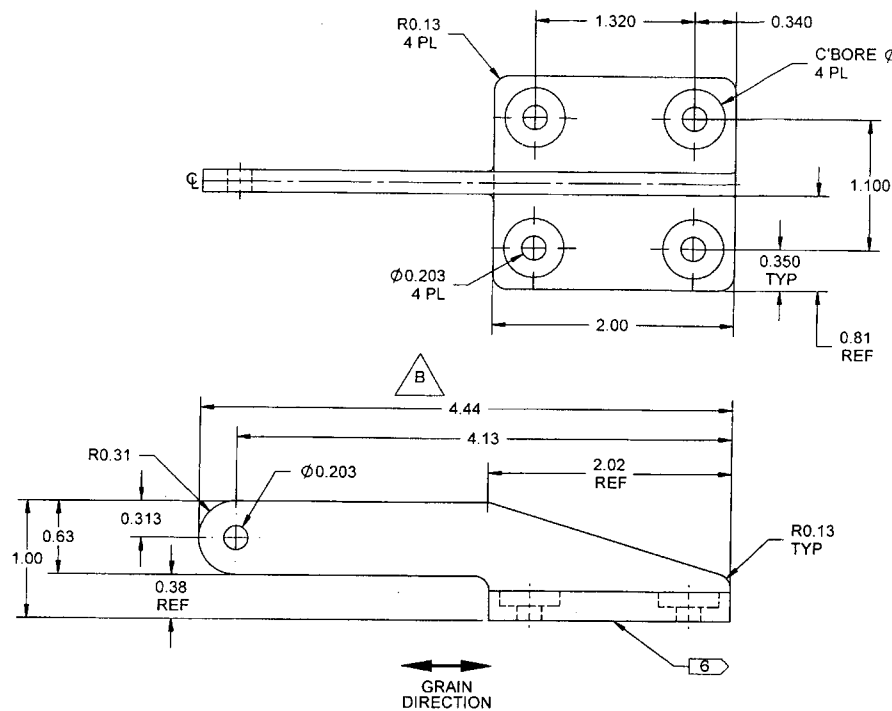
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NOTE: Date & initial all entries



D4073-1 DOOR HINGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82355 MLO
12/03/29

RELEASED
2011-06-30
M

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.05.02		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D4073	REV. B
TITLE DOOR HINGE	SCALE NTS
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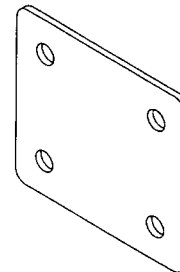
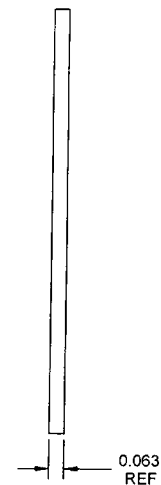
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92355

RELEASED
2011-06-30
ND

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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DESIGN	15	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	11	DRAWING NO.	REV. B
MFG. APPR.	21	D4073	SHEET 2 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	11	DOOR HINGE	NTS
DATE	11.05.02	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMERCE OR CONFRONTED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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